

Ship ASAP - Ecefe

Work Order ID 71529

Wednesday, July 06, 2011 11:09:47 AM



PRELIMINARY ISSUE

Item ID: D4331-1

Revision ID: PRELIM

Item Name: Doubler

Start Date: 7/6/2011 Start Qty: 1.00

Required Date: 7/7/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *[Signature]* Date:

QC: Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling: Date:

SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D4331 PA1

100 0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

2024.080

1-Cut as per Dwg D4331

Dwg Rev: *PA1*

Prog Rev: *PA1*

2-Deburr if necessary

1811-7-6

(2)

110 0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

1811-7-6

120 0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

= inspected to PA1

Dwg only

8/17/7

(12)

Work Order ID 71529

Wednesday, July 06, 2011 11:09:47 AM



Page 2

Item ID: D4331-1
Revision ID: PRELIM
Item Name: Doubler

Accept



Setup Start
Stop



Start Date: 7/6/2011 Start Qty: 1.00
Required Date: 7/7/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start
Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab	Small Fab	0.00				②			
Small Fab	Memo	0.00							
Small Fab	FORM AS PER DWG								
150 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
160 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

SB 11/07/07

inspect to PBI
Day only
8/11/12 (2)

2 BR 11-7-12.

Work Order ID 71529

Wednesday, July 06, 2011 11:09:47 AM



Item ID: D4331-1

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Doubler

Start Date: 7/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1X ϕ M/L 11/07/12

180

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/7/12 ϕ ∞

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

UHF 11-07-12

POSITIVE RECALL

EFFECTIVE 11/07/06 AUTH u

RELEASED _____ DATE _____

Picklist Print

Wednesday, July 06, 2011 11:09:44 AM

Page 1

Work Order ID: 71529

Parent Item: D4331-1

Parent Item Name: Doubler





Start Date: 7/6/2011

Required Date: 7/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-07-05 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080  2024-T3 .080 sheet		Purchased	No				sf	205.1000		1.631579	3.		
											B11-7-6		

Location

Loc Qty

Loc Code

MAT022

205.1

105411

6

109424

4

110347

0.5

110908

3

112331

3

113796

7

114025

15.7

116604

5.8

117392

40.1

118180

120

110908

②

DART AEROSPACE LTD		Work Order: 71529
Description: Double		Part Number: D4331-1
Inspection Dwg: D4331-1 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .125	+ .004 - .001	.125	✓		V 1802	
Ø .129	+ .005 - .001	.128	✓		V	
Ø .161	+ .005 - .001	.161	✓		V	
Ø .625	+ .008 - .001	.624	✓		V	
Ø .938	+ .010 - .001	.938	✓		V	
.40	± .030	.404	✓		V	
1.15	± .030	1.152	✓		V	
2.96	± .030	2.960	✓		V	
3.36	± .030	3.361	✓		V	
3.33	± .030	3.333	✓		V	
3.77	± .030	3.777	✓		V	
4.21	± .030	4.212	✓		V	
4.61	± .030	4.614	✓		V	
5.86	± .030	5.869	✓		V	
6.11	± .030	6.117	✓		V	
6.46	± .030	6.485	✓		V	
6.86	± .030	6.863	✓		V	
7.11	± .030	7.112	✓		V	
8.36	± .030	8.361	✓		PROW 502	
9.61	± .030	9.613	✓		P	
9.96	± .030	9.958	✓		P	
10.21	± .030	10.21	✓		P	
10.46	± .030	10.460	✓		P	

Measured by: RB
Date: 11-7-7

Audited by: S
Date: 11/7/7

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 71529
Description: DOUBLER		Part Number: D4331-1
Inspection Dwg: D4331-1 Rev: PAT		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.86	±.030	10.863	✓		PRGW302	
12.11	±.030	12.11	✓		T B01	
13.36	±.030	13.36	✓		T	
13.96	±.030	13.96	✓		T	
.79	±.030	.791	✓		V B02	
1.14	±.030	1.145	✓		V	
1.23	±.030	1.227	✓		V	
1.48	±.030	1.486	✓		V	
1.67	±.030	1.666	✓		V	
1.82	±.030	1.825	✓		V	
2.777	±.010	2.776	✓		V	
2.96	±.030	2.964	✓		V	
3.36	±.030	3.364	✓		V	
3.652	±.010	3.655	✓		V	
4.11	±.030	4.111	✓		V	
4.652	±.010	4.655	✓		V	
4.86	±.030	4.864	✓		V	
5.61	±.030	5.615	✓		V	
5.652	±.010	5.659	✓		V	
6.36	±.030	6.358	✓		V	
6.652	±.010	6.655	✓		V	
7.11	±.030	7.114	✓		V	
7.652	±.010	7.652	✓		V	

Measured by: IB	Audited by: S	Prototype Approval:
Date: 11-7-7	Date: 11/7/7	Date:

Rev A	Date	Change New Issue	Revised by KJ/JLM	Approved
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DART AEROSPACE LTD		Work Order: 71529
Description: Doublet		Part Number: D4331-1
Inspection Dwg: D4331-1 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.86	± .030	7.856	✓		P Row 502	
8.61	± .030	8.611	✓		P	
8.62	± .010	8.655	✗		P	
9.36	± .030	9.365	✓		P	
9.65	± .010	9.657	✓		P	
10.11	± .030	10.115	✓		P	
10.527	± .010	10.531	✓		P	
10.86	± .030	10.865	✓		P	
11.61	± .030	11.615	✓		P	
12.36	± .030	12.36	✓		T Bo1	
13.11	± .030	13.11	✓		T	
13.86	± .030	13.86	✓		T	
14.61	± .030	14.61	✓		T	
15.36	± .030	15.36	✓		T	
15.71	± .030	15.71	✓		T	
2.90	± .030	2.904	✓		V Bo2	
3.50	± .030	3.508	✓		V	
10.96	± .030	10.961	✓		P	
1.080	± .010	1.077	✓		V	

Measured by: RB	Audited by: [Signature]	Prototype Approval:
Date: 11-7-7	Date: 11/7/7	Date:

Rev A	Date	Change to PA1 Dwg	Revised by KJ/JLM	Approved
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DART AEROSPACE LTD		Work Order:	71579
Description: Doubler		Part Number:	D4331-1 (Bent)
Inspection Dwg: D4331	Rev: P21	* Page 1 of 1	

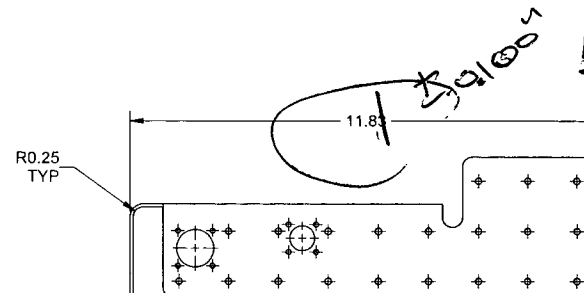
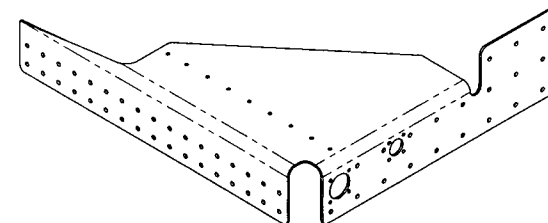
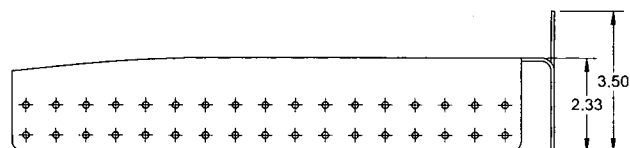
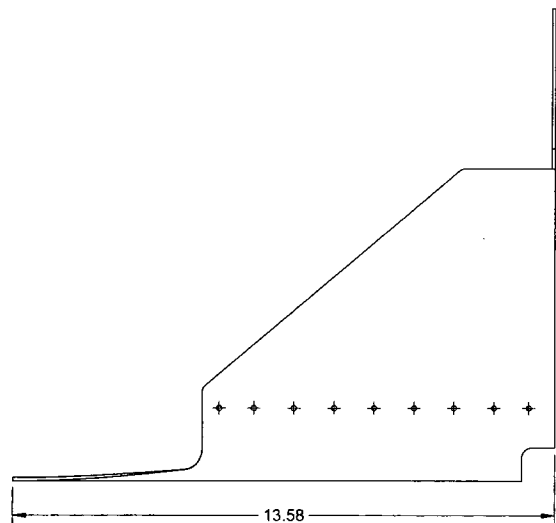
☒ **First Article** ☐ **Prototype**

[illegible]

Measured by:	SB	Audited by:	J	Prototype Approval:	N/A
Date:	11/07/11	Date:	11/7/11	Date:	N/A

10 Rev PA1.

Rev	Date	Change	Revised by	Approved
A		New Issue	KJJ/JLM	



ACCEPTABLE - HARVEY
TO UPDATE DWG TO
QRE D4331-1 PL

11.07.11

D4331-1 DOUBLER

PRELIMINARY ISSUE

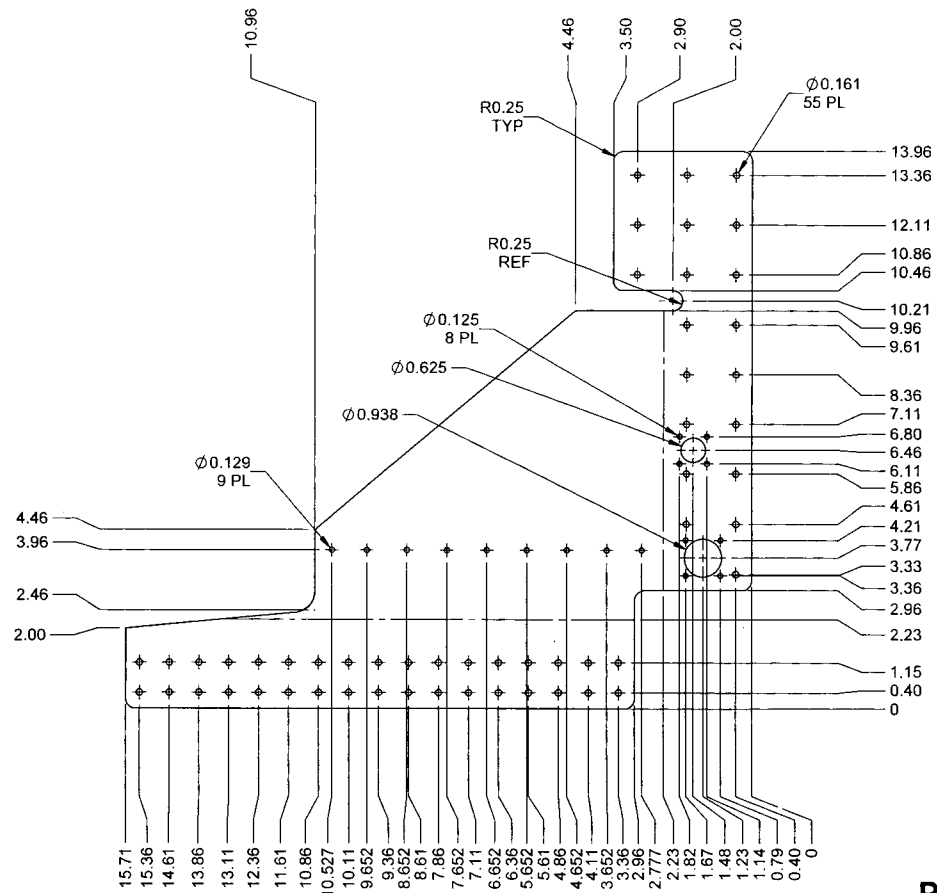
11.02.03

Handwritten signature and date: 11.07.11

NOTES:

- 1) MATERIAL: MADE FROM D4331-1F
- 2) FINISH: PRIME PER QSI 005 4.2.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4331	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	11.02.03	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



PRELIMINARY ISSUE
11.02.03

D4331-1F

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.072 THICK
REF DART SPEC M2024T3S.072
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN	JS	DART AEROSPACE LTD	
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CHECKED	JS	DRAWING NO.	REV. PA1
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APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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